

**Work Order ID 66810**

Monday, February 28, 2011 10:37:34 AM



Page 1

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350 )

Start Date: 2/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*R*

Date:

*1-02-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4018

C

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *115928* 0.00  
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B  
2- weld hinge (3) and Mounting brackets as per dwg D4018  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D4018  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

*Ppl 11.03.17*

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

*1 8 BE 11/03/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*5/10/18*



130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

*M 112588.*

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time: *8:10*

Oven Temperature: *320°*

Finish Time: *8:40*

*1 BR 11-3-18.*

140

Wing Walk as per dwg QSI005 4.4 Batch *1116 4002*

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- install label

*1 8/10/18*

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 3/11/2011 Req'd Qty: 1.00

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 11/03/18 ①

160

Identify as per dwg & Stock Location: G-A

0.00



Packaging

W/O 66744

Memo

0.00

Packaging

ES 11/03/18 ①

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/18 ②

CZ 11/03/18

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**NOTE:** Date & initial all entries

Monday, February 28, 2011 10:37:41 AM








Page 1

**00000000000000000000000000000000**

**Required Date:** 3/11/2011

**Required Qty: 1.00**

**Comments:** IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1 		Manufactured	No			100	Each	3.0000	2	2			
Rib													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			3						
				65915			2						
				66557			1						
D4018-3 		Manufactured	No			100	Each	0.0000	2	2			
Rib													
D4016-3		Manufactured	No			100	Each	15.0000	3	3			
Hinge Half, Lid													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			15						
				65951			12						
				66286			3						
D4018-5 		Manufactured	No			100	Each	34.0000	6	6			
Rib													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			34						
				65428			4						
				66289			30						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, February 28, 2011 10:37:41 AM

Page 2

Work Order ID: 66810

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 2/28/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100

Each

2.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA

2

66498

2

D4035-043

Manufactured No

100

Each

4.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA

4

66288

1

66499

1

66544

2

D2581

Manufactured No

100

Each

22.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

22

64112

1

65950

21

D4020-7

Manufactured No

100

Each

2.0000

1

1



Mesh (350 Basket Short, Lid)

Location

Loc Qty

Loc Code

WA

2

66474

2

*Pl 11-03-17*

*Pl 11-03-17*

*Pl 11-03-17*

*360500 → ②*

*Pl 11-03-17*

*①*

Monday, February 28, 2011 10:37:42 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, February 28, 2011 10:37:42 AM

Page 3

Work Order ID: 66810

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 2/28/2011

Required Date: 3/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured No

100

Each

6.0000

1

1



Data Plate



*PL 11.03.17*

Location

Loc Qty

Loc Code

WA

6

56050

1

65916

1

65922

4

D2728-3

Manufactured No

140

Each

0.0000

1



Dart Logo label



*(X1) M115050 PL 11.03.17*

Monday, February 28, 2011 10:37:42 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

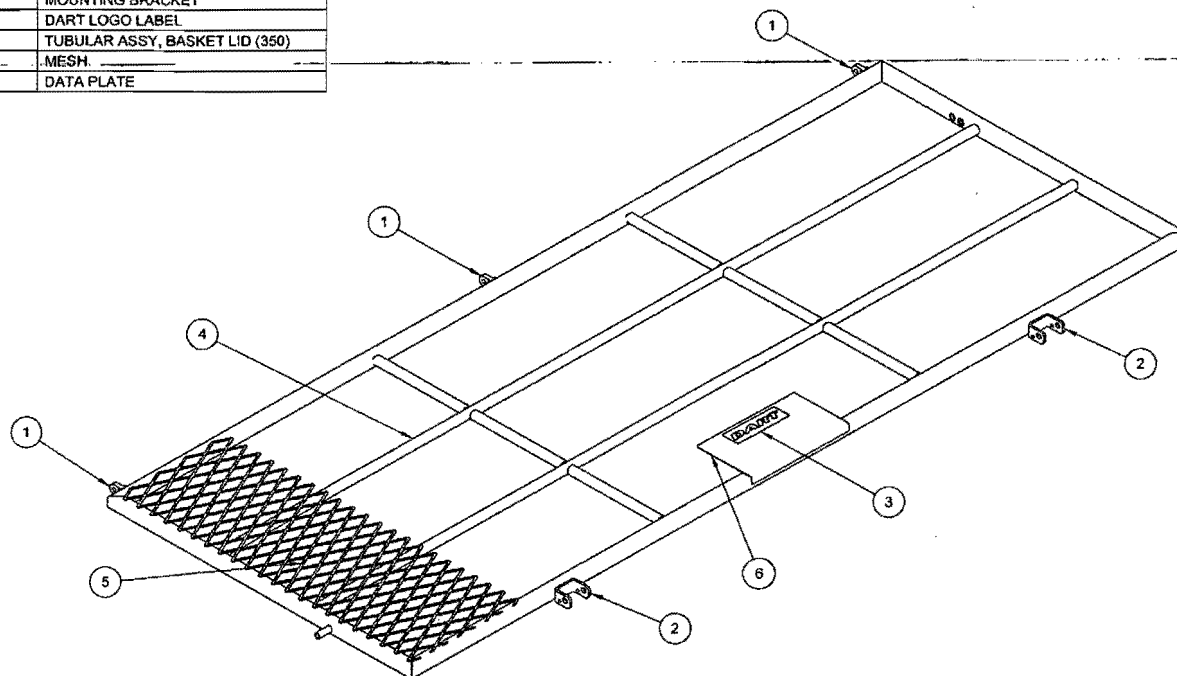
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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 64510

*PLN-02-20*

RELEASED  
10.08.05  
ECIS 10-916

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>SC</i>	D4018	SHEET 1 OF 4
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

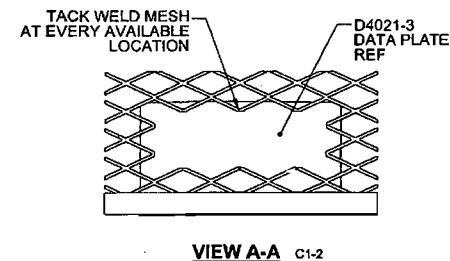
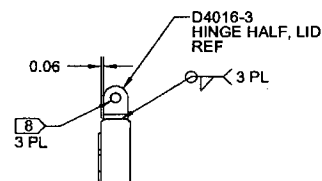
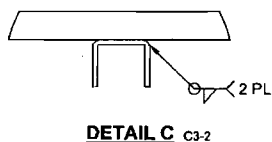
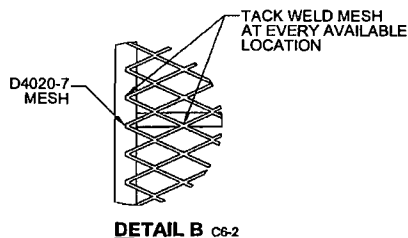
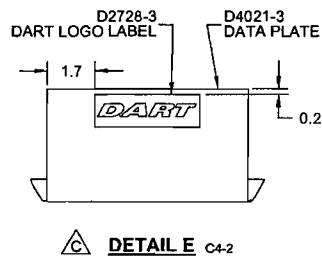
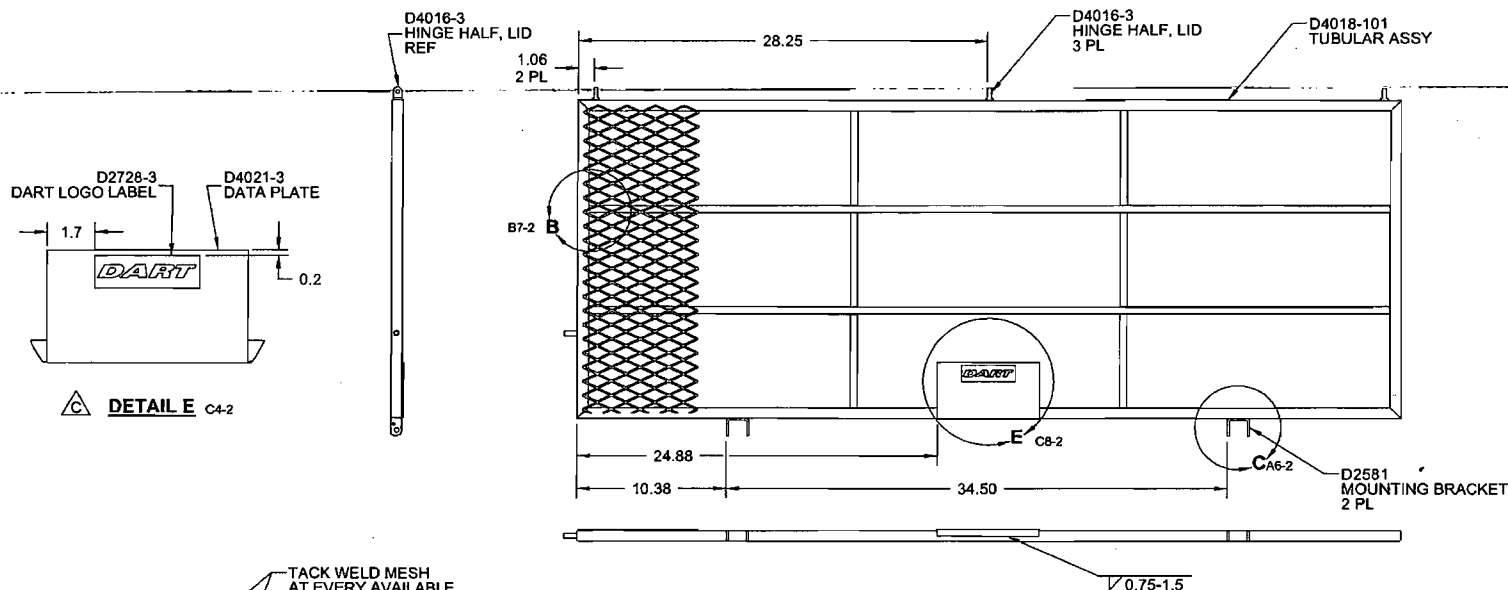
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

WU 46810



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
10 48 12

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.5 lbs APPROX
  - 8) MASK HOLES PRIOR TO FINISHING
  - 9) WELD PER DART QSI 004

**DETAIL D D1-2**

DESIGN	AKS	<b>DART AEROSPACE LTD</b>	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	ND	<b>D4018</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>SHORT BASKET LID ASSY (350)</b>	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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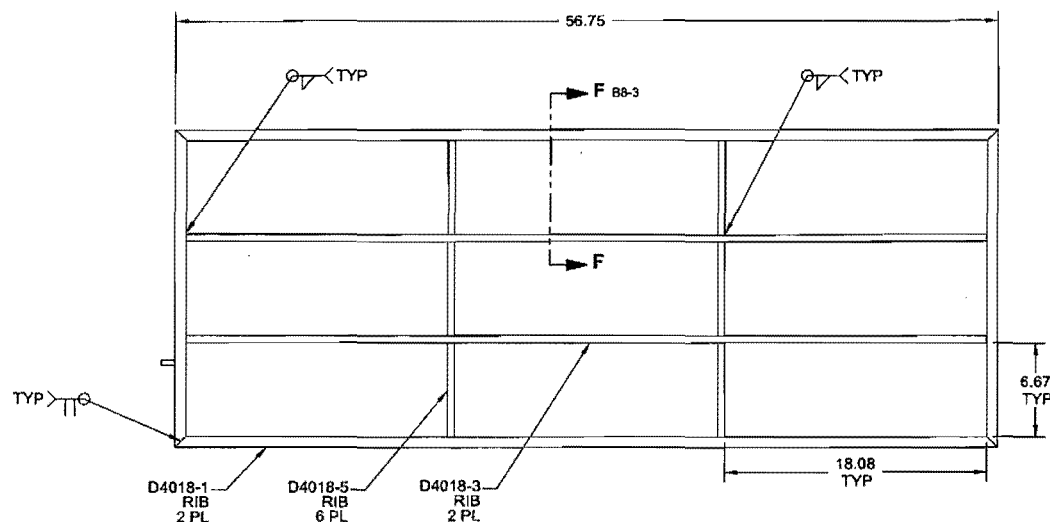
u/b 66810

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

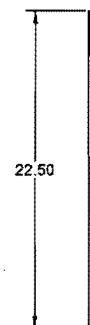


D4035-041  
RIB ASSY, FWD

SECTION F-F C3-3



8 D4018-101 TUBULAR ASSY, BASKET LID (350)



D4035-043  
RIB ASSY, AFT

RELEASED  
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LS	DRAWING NO. D4018	REV. C
CHECKED	SC		SHEET 3 OF 4
MFG. APPR.	MS	TITLE SHORT BASKET LID ASSY (350)	SCALE NTS
APPROVED	MS	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DE APPR.	MS	THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.08.05		

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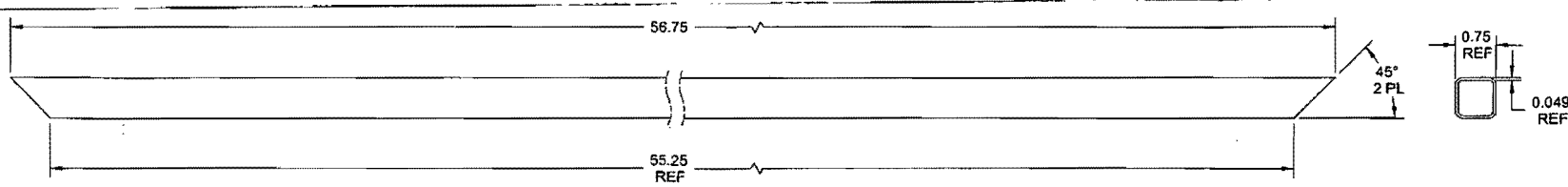
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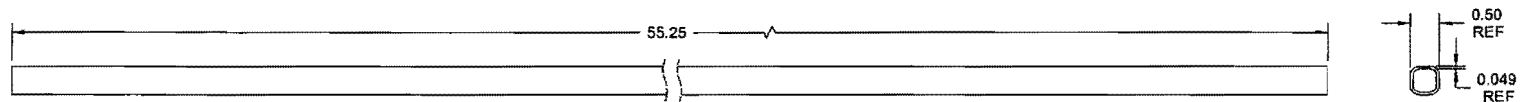
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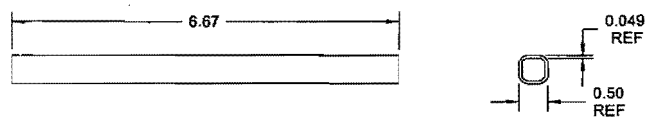
u/a 46810



**D4018-1 RIB**



**D4018-3 RIB**



**D4018-5 RIB**

**NOTES:**

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
10.08.05

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JSC	DRAWING NO.	REV. C
MFG. APPR.	W	<b>D4018</b>	SHEET 4 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	H	<b>SHORT BASKET LID ASSY (350)</b>	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries